

IN THE CLAIMS:

1-17. (Canceled)

18. (Previously presented): A method for manufacturing an elastic doll comprising the steps of:

insert molding second cores on each of flexible first cores so as to be spaced from each other using a skeleton forming material of a rigid synthetic resin, to thereby form a skeleton member including said first and second cores connected to each other; and

insert molding a skin/flesh member on said skeleton member using a skin/flesh forming material of a soft synthetic resin whereby the rigid synthetic resin and the soft synthetic resin are compatibly welded together.

19. (Canceled)

20. (Previously presented): A method for manufacturing an elastic doll as defined in claim 18, wherein said skeleton forming material is polyolefin resin and said skin/flesh forming material is an elastomer.

21. (Previously presented): A method for manufacturing an elastic doll as defined in claim 18 wherein the elastic doll includes a trunk, arms and legs in which said skeleton member is embedded;

said step of insert molding said second cores includes forming fixing shafts which extend from said second cores to a surface of the doll; and

said step of insert molding said skin/flesh member includes arranging said skeleton member in a mold for molding the skin/flesh member, fixing said fixing shafts on mating surfaces of said mold to stabilize said skeleton member and injecting the soft synthetic resin into said mold,

10 further comprising the steps of removing portions of said fixing shafts projected
11 from the surface of the doll after molding and treating marks left on the surface of the doll due to
12 removal of the projected portions of said fixing shafts.

1 22. (Original): A method for manufacturing an elastic doll as defined in claim 21,
2 wherein said step of treating said marks is carried out by melting the surface of the doll.

1 23. (Original): A method for manufacturing an elastic doll as defined in claim 21,
2 wherein said skeleton member includes a foot skeleton section incorporated in each of said legs;
3 and

4 said step of insert molding said skin/flesh member includes directly abutting a
5 rear surface of a distal end of each of said second cores corresponding to said foot skeleton
6 section against an inner surface of molding spaces in the mold, to thereby securely hold said
7 second cores therein.

1 24. (Original): A method for manufacturing an elastic doll as defined in claim 21,
2 wherein said first cores are each made of metal;

3 said skeleton member is constituted by said first cores which are arranged at sites
4 in the doll corresponding to joints and said second cores which are arranged at sites in the doll
5 corresponding to distal ends thereof and positions between joints adjacent to each other; and

6 said trunk includes three of said first cores arranged therein so as to be vertically
7 extended;

8 an outer two of said three first cores being inwardly curved with respect to each
9 other.

1 25. (Original): A method for manufacturing an elastic doll as defined in claim 21,
2 wherein said second cores are formed at a place thereon facing a joint with small projections.

1 26. (Original): A method for manufacturing an elastic doll as defined in claim 21,
2 wherein said fixing shafts are each arranged at a site in the doll at which an injection pressure of
3 the soft synthetic resin is unstable when the soft synthetic resin is injected into said mold.

1 27. (Previously presented): A method for manufacturing an elastic doll which
2 includes a trunk, arms and legs in which a skeleton member is embedded, comprising the steps
3 of:

4 providing cores made of rigid synthetic resin to constitute said skeleton member
5 wherein fixing shafts are formed to extend from said cores to a surface of the doll;

6 arranging said skeleton member in a mold and fixing said fixing shafts on mating
7 surfaces of said mold to stabilize said skeleton member;

8 injecting soft synthetic resin into said mold; and

9 removing portions of said fixing shafts projected from the surface of the doll after
10 molding and treating marks left on the surface of the doll due to removal of the projected
11 portions of said fixing shafts, the soft synthetic resin and rigid synthetic resin are welded together
12 within the mold.

1 28. (Original): A method for manufacturing an elastic doll as defined in claim 27,
2 wherein said treating of said marks is carried out by melting the surface of the doll.

1 29. (Original): A method for manufacturing an elastic doll as defined in claim 27,
2 wherein said skeleton member includes a foot skeleton section incorporated in each of said legs;
3 and
4 a rear surface of a distal end of each of said cores corresponding to said foot
5 skeleton section is directly abutted against an inner surface of molding spaces in the mold, to
6 thereby be securely held therein.

1 30. (Original): A method for manufacturing an elastic doll as defined in claim 27,
2 wherein said skeleton member is constituted by first cores made of metal and arranged at sites in
3 the doll corresponding to joints and second cores made of rigid synthetic resin and arranged at
4 sites in the doll corresponding to distal ends thereof and positions between joints adjacent to each
5 other; and
6 said trunk includes three of said first cores arranged therein so as to be vertically
7 extended;
8 an outer two of said three first cores being inwardly curved with respect to each
9 other.

1 31. (Original): A method for manufacturing an elastic doll as defined in claim 27,
2 wherein the cores of said skeleton member are formed at a place thereon facing a joint with small
3 projections.

1 32. (Original): A method for manufacturing an elastic doll as defined in claim 27,
2 wherein said fixing shafts are each arranged at a site in the doll at which an injection pressure of
3 the soft synthetic resin is unstable when the soft synthetic resin is injected into said mold.

1 33-56 (Canceled)

1 57. (Previously presented): A method for manufacturing an elastic doll as defined in
2 claim 18 wherein the elastic doll includes a trunk, arms and legs in which said skeleton member
3 is embedded;

4 said step of insert molding said second cores includes forming fixing shafts which
5 extend from said second cores to a surface of the doll; and

6 said step of insert molding said skin/flesh member includes arranging said
7 skeleton member in a mold for molding the skin/flesh member, fixing said fixing shafts on
8 mating surfaces of said mold to stabilize said skeleton member and injecting the soft synthetic
9 resin into said mold,

10 further comprising the steps of removing portions of said fixing shafts projected
11 from the surface of the doll after molding and treating marks left on the surface of the doll due to
12 removal of the projected portions of said fixing shafts by a hot air procedure to melt the surface
13 adjacent the marks and the flexible first cores are formed of one of a stainless steel and iron
14 fixedly attached to the second cores.

1 58. (Currently amended): A method of forming a doll with simulated bending
2 appendages to simulate a living creature, comprising:

3 forming a metal frame;

4 covering the metal frame with a first synthetic resin material with a first hardness
5 value ~~within a range of 25 to 35~~ to limit bending of the metal frame;

6 molding a plurality of rigid core sections at positions spaced along the metal
7 frame while exposing the covered metal frame in positions corresponding to anatomical joints of
8 the living creature; and

9 molding a second soft synthetic resin having a second hardness value to surround
10 the metal frame and the plurality of rigid core sections to simulate the tissue of the living
11 creature, the second hardness value is greater than the first hardness value.

1 59. (Previously presented): The method of forming a doll as defined in Claim 58
2 wherein the metal frame includes a plurality of wire members bent to provide a pair of
3 substantially parallel portions extending from a bent intermediate section.

1 60. (Previously presented): The method of forming a doll as defined in Claim 59
2 wherein the first synthetic resin and the second synthetic resin are formed of compatible
3 thermoplastic elastomers to weld together when contacting each other in a mold.

1 61. (Previously presented): The method of forming a doll as defined in Claim 60
2 wherein the metal frame is principally formed of iron.

1 62. (Previously presented): The method of forming a doll as defined in Claim 61
2 wherein the metal frame is held magnetically during the molding steps.

1 63. (Previously presented): The method of forming a doll as defined in Claim 60
2 wherein the rigid core sections are molded of a polyolefin resin and the second soft synthetic
3 resin is an elastomer.

1 64. (Currently amended): The method of forming a doll as defined in Claim 60
2 wherein the rigid core sections are molded of a polypropylene and the second soft synthetic resin
3 is a styrene ~~with a hardness value within a range of 10 to 20~~ elastomer.

1 65. (Previously presented): The method of forming a doll as defined in Class 64
2 wherein the first synthetic resin material is a styrene elastomer.